PRODUCT DATA SHEET
AWLCRAFT 2000 METALLICS

Features & Uses

AWLCRAFT® 2000 Metallics are mixed and applied the same way as conventional AWLCRAFT 2000 topcoats. Through the use of flow stabilizers, metallic flake float has been drastically reduced, and color consistency is improved. These new formulas will allow applicators to quickly and easily apply metallics for a finish with outstanding color, brilliance and luster.

AWLCRAFT 2000 metallic flakes are pre-mixed into the pigmented color base which is applied in the same way as conventional pigmented AWLCRAFT 2000 topcoats.

Notes:- Metallic topcoats must be applied over the appropriate Awlgrip primer or Awlcraft 2000 topcoat that has cured 12 to 24 hours and has been sanded until all gloss is removed.
- (Optional) Metallics may be clear coated when applied as a base coat/clear coat application.
- Large area applications such as hull sides will require additional application techniques. Use of an agitated pressure pot is essential for these large areas. Contact your Awlgrip Technical Sales Representative for additional information.

Specification Data

Type: Two Component Acrylic Urethane Metallic
Packaging: Color base available in Gallons and Quarts at your local Awlmix distributors.
Theoretical Coverage: Sq. Ft./Gallon 512 Sq. Feet (48m^2) at one mil dry (25 microns)
171-256 Sq. Feet (16-24m^2) at recommended dry film thickness. Calculated for mixed base and converter, reduced 25% to 35%
Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size, and application environment.
Recommended Wet Film Thickness: 6-9 mils (150-225 microns) total of 2-3 coats.
Recommended Dry Film Thickness: 2-3 mils (50-75 microns) total of 2-3 coats.
Anticipated Cure Time at 77°F, 50% R.H: 24 Hours to tape free; 3 days to light service; 14 days for full cure.
Recoatability: Spray applications consist of 2 to 3 coats applied over 1-4 hours. Exact time will vary with temperature, project size, and film thickness applied. AWLCRAFT 2000 clear coat can be applied after 2 hours at 77°F (25°C) but before 8 hours of cure. The last coat of metallic should be dry to touch to prevent mottling of the metallic. If sanding is desired, apply 2 coats of AWLCRAFT 2000 Clear (F3029) and allow curing over night before sanding. AWLCRAFT® 2000 Metallics which have been allowed to cure more than 24 hours must be sanded and recoated with AWLCRAFT 2000 Metallic before recoating with F3029 clear coat.

VOC: Base (e.g. F4161): 472.5 g/lt or 3.9 lbs/gallon
Converter (G3010): 591 g/lt or 4.9 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

AWLCRAFT 2000 Metallic Base ..... F-Code
AWLCRAFT 2000 Gloss Clear F3029
AWL-CAT #2 Spray Converter G3010
Fast Evaporating Reducer-Spray T0001
Very Fast Evaporating Reducer-Spray T0002
Standard Evaporating Reducer-Spray T0003
Hot Weather Reducer-Spray T0005
Equipment Cleaning ..... T0001, T0002, T0003, or M.E.K.

1 East Water Street • Waukegan, Illinois 60085 • USA • Tel: 847.599.6212 • Fax: 847.599.6209
Bannerlaan 54 • B-2280 Grobbendonk • Belgium • Intl. Tel: 32.14.257770 • Intl. Fax: 32.14.230880
76 Waterway Drive • Coomera • QLD 4209 • Australia • Tel: 61.7.5573.9600 or 1800.007.866 • Fax: 61.7.5573.9677
449 Tagore Industrial Avenue • 01-03 Hong Joo Industrial Building • Singapore 787820 • Tel: 65.6453.1981 • Fax: 65.6453.1778

Application Equipment

Conventional air atomized spray or HVLP spray. Metallic urethanes are spray only.

SPRAY EQUIPMENT

Pressure Pot System
Devilbiss or equivalent:
Spray Gun: JGA-510
Fluid Nozzle: FX – 1.1
Fluid Needle: 1.1
Air Nozzle: 704
PP PSI: 8-12 PSI
GUN PSI: 50-60 PSI

Cup Gun System
SATA jet 3000 RP:
Needle / Nozzle: 1.3 mm
PSI: 35 PSI

HVLP *may not provide enough atomization to get uniform distribution of the pearl or metallic particle. Standard conventional, air atomized spray gun is preferred.*

Surface Preparation

AWLCRAFT® 2000 metallics should be applied over the appropriate Awlgrip primer or Awlcraft 2000 topcoat. The primed surface must be clean and dry. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with 320 grit paper before topcoat application. When applying metallics over Awlcraft 2000 topcoats, sand the surface with 400-500 grit paper.

Mixing and Reduction

Spray Only: Mix by volume two parts AWLCRAFT® 2000 Topcoat Base component with one part AWL-CAT #2 (G3010) Spray converter to a smooth, homogenous mixture. Reduce 30%-35% with T0001 or T0002 Reducer. Overall mix is 2:1:¾-1 by volume. Example: 8 oz. Base, 4 oz. G3010, and 3-4 oz. Reducer. Clear coats, metallic colors, and painting in high temperature conditions may require additional reduction.

AWLCRAFT 2000 metallics are designed for spray application only and have a significantly shorter pot life than pigmented topcoats. Do not add accelerators to metallic topcoats.

Application Instructions

Apply by spray in light, slightly wet coats until hide is achieved, most AWLCRAFT 2000 metallic topcoats achieve hide in 2 to 3 coats. Allow 20 to 40 minutes tack time between coats. This spray method allows uniform development of the metallic color without flooding or floating the metallic particles. After achieving the specified color, allow the coating to cure a minimum of 2 hours at 77°F (25°C) but not more than 8 hours before clear applications.

Metallics may be clear coated when applied as a base coat/clear coat application.

After achieving the desired color, allow the coating to cure a minimum of 2 hours but not more than 8 hours. The last coat of metallic should be dry to touch to prevent mottling of the metallic. Within this period, seal the AWLCRAFT 2000 metallic with AWLCRAFT 2000 Gloss Clear (F3029/G3010). Mix by volume two parts F3029 AWLCRAFT 2000 Clear with one part AWL-CAT #2 (G3010) Spray Converter to a smooth, homogenous mixture. Reduce 30% to 35% with T0001 or T0002 Reducer. Overall mix is 2:1:1 by volume for example: 8 oz. Base, 4 oz. G3010, 4 oz. Reducer.

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Warning:

Temperature Range: Optimal Surface/Ambient Temperature range is 18°C (60°F) to 35°C (95°F). Proper application and/or cure results may be more difficult to achieve when conditions are outside this range.

Do not apply paint materials to surfaces less than 3°C (5°F) above dew point, or to surfaces warmer than 41°C (105°F). Ambient temperature should be minimum 10°C (50°F) and maximum 41°C (105°F).

Do not use accelerators in Metallic Coatings.

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